

PRELIMINARY ISSUE

Work Order ID 61965

Monday, September 13, 2010 11:15:45 AM

Page 1

Item ID:	D4173-1	Accept		Setup	Start	
Revision ID:	PRELIM					
Item Name:	Pod Radalt Mounting Plate				Stop	
Start Date:	9/13/2010	Start Qty: 2.00		Cust Item ID:		
Required Date:	9/20/2010	Req'd Qty: 2.00		Customer:		

Reference:

Approvals:	Process Plan:		Date: 10-9-13	Tooling:	Date:	Run	Start	
	QC:		Date: _____	SPC (Y/N):	Date: _____	Stop		

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	Memo	0.00	10-9-14	(2)
100		Waterjet	0.00		
		Memo	0.00		
		1-Cut as per Dwg Dwg Rev: PA1 Prog Rev: PA1			
		2-Deburr if necessary	PA2 same dim. as PA1 10-9-16		
110		QC2- Inspect parts off machine FAI/FAIB	0.00	10-9-14	
		Memo	0.00		
		QC			
		Quality Control			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61965

Page 2

Monday, September 13, 2010 11:15:45 AM

Item ID: D4173-1

Accept



Setup Start



Revision ID: PRELIM

Item Name: Pod Radalt Mounting Plate

Stop



Start Date: 9/13/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 9/20/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

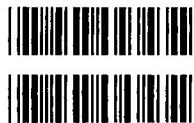
Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description**Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00 - inspected to P#1

Dug only

(x2)

130



Brake NC

Brake NC

Bend as per dwg

0.00

SB 10/9/16

(x2)

0.00

Memo

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00 - inspected to P#1

Dug only

(x2)

Memo

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61965

Monday, September 13, 2010 11:15:45 AM



Page 3

Item ID: D4173-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Pod Radalt Mounting Plate

Start Date: 9/13/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 9/20/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

150

Identify as per dwg & Stock Location: W4
use on w/o 61963

Packaging

Packaging

160



QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

*fl 10.09.20**2**fl*

0.00

QC21- Final Inspection - Work Order Release

0.00



Memo

0.00

Quality Control

*10/09/29 fl**10.09.20***POSITIVE RECALL**EFFECTIVE 10.09.13 AUTH URELEASED 1 DATE 10.09.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Monday, September 13, 2010 11:15:50 AM

Work Order ID: 61965



Parent Item: D4173-1



Parent Item Name: Pod Radalt Mounting Plate

Start Date: 9/13/2010

Required Date: 9/20/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.09.08 new issue verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 		Purchased	No			100	sf	101.4340	0.41	0.863158		 IB 10-9-14	

6061-T6 .063 Sheet

Location	Loc Oty	Loc Code
MAT21	101.434	
113608	101.434	

113608

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

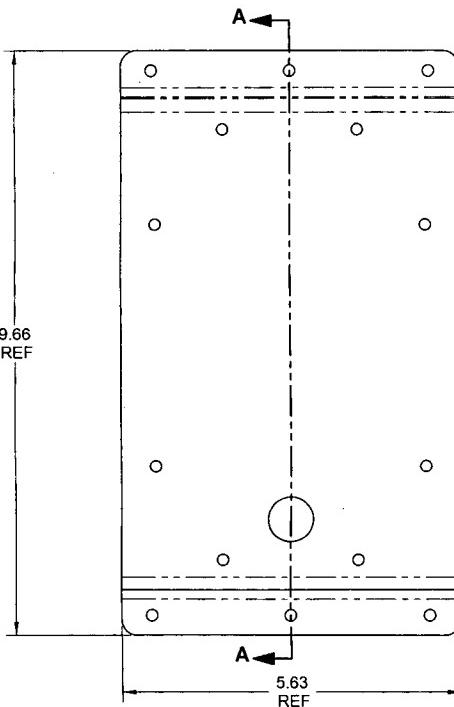
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

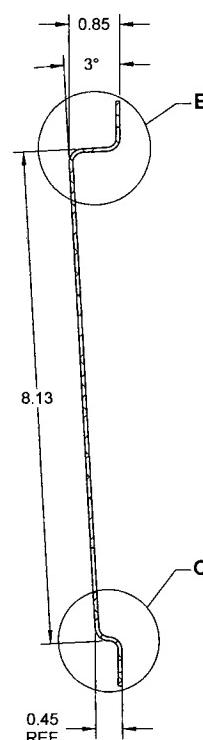
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

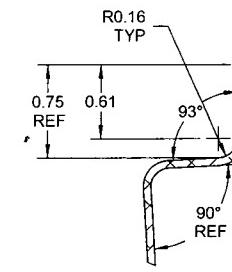
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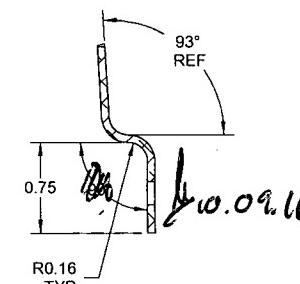
D4173-1 POD RADALT MOUNTING PLATE



SECTION A-A



DETAIL B
SCALE 2X



DETAIL C
SCALE 2X

- NOTES:
 1) MATERIAL: MAKE FROM D4173-1F
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 0.50 lbs

PRELIMINARY ISSUE
10.09.08

10.09.08

DESIGN	b	DART AEROSPACE LTD
DRAWN	b	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		REV. PA1
APPROVED		D4173 SHEET 3 OF 7
DE APPR.		TITLE
DATE	10.09.01	POD RADALT MOUNTING PLATE ASSY NTS

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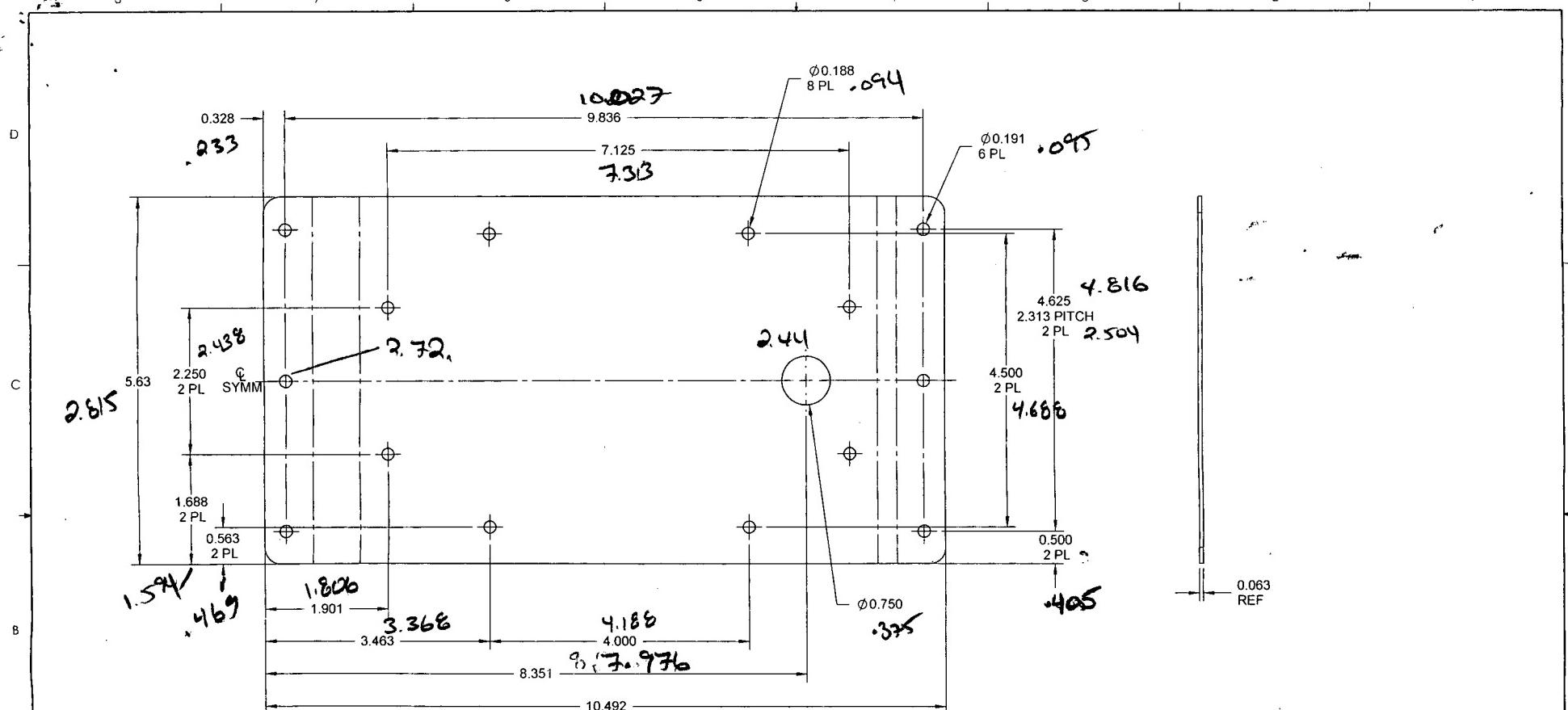
8 7 6 5 4 3 2 1

D

C

B

A



D4173-1F POD RADALT MOUNTING PLATE FLAT PATTERN

PRELIMINARY ISSUE

10.09.08

NOTES:

- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.36 lbs

10.09.08

DESIGN	<i>10</i>	DART AEROSPACE LTD	
DRAWN	<i>10</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.		D4173	REV. PA1
APPROVED		TITLE	SHEET 4 OF 7
DE APPR.		POD RADALT MOUNTING PLATE ASSY NTS	
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DART AEROSPACE LTD	Work Order:	61965
Description: Pod Radial Mounting Plate	Part Number:	D4173-1
Inspection Dwg: D4173-1 Rev: P41		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

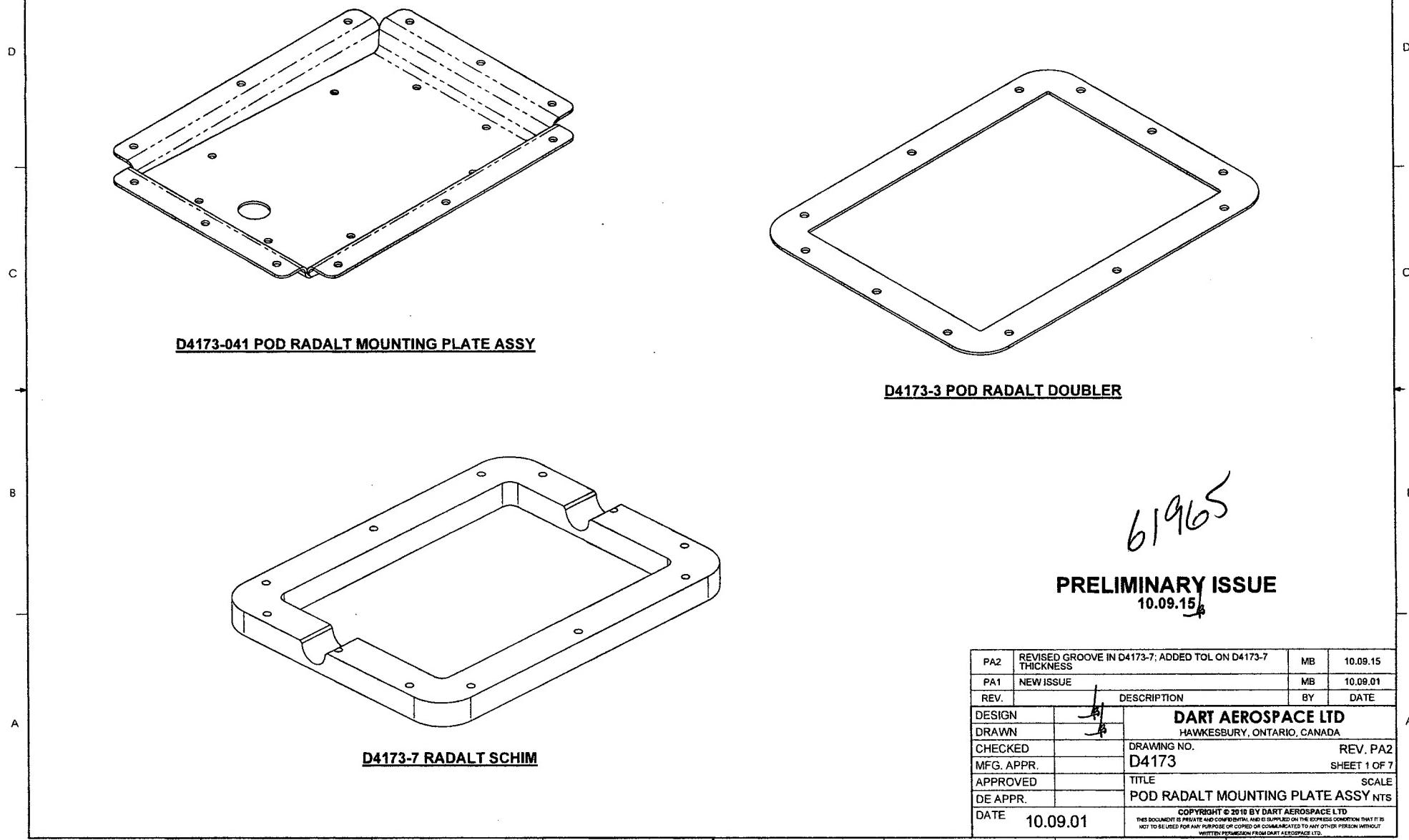
X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
$\phi .188$	$+.005 -.001$.189	X		V	HB02
$\phi .191$	$+.005 -.001$.192	X	*	V	
$\phi .750$	$+.008 -.001$.750	X		V	
.328	$+.010$.330	X		V	
9.836	$+.010$	9.837	X		V	
7.125	$+.010$	7.121	X		V	
4.625	$+.010$	4.624	X		V	
2.313	$+.010$	2.313	X		V	
4.500	$+.010$	4.503	X		V	
.500	$+.010$.503	X		V	
10.497	$-.010$	10.496	X		V	PROD
8.351	$-.010$	8.351	X		V	PROD
4.000	$-.010$	4.001	X		V	
3.463	$-.010$	3.465	X		V	
1.901	$-.010$	1.901	X		V	
.563	$-.010$.564	X		V	
1.688	$-.010$	1.688	X		V	
2.750	$-.010$	2.748	X		V	
5.63	$-.030$	5.630	X		V	
.063	$-.010$.060	X		V	

Measured by:	R	Audited by:	S	Prototype Approval:	N/A
Date:	10-9-14	Date:	10/09/14	Date:	N/A

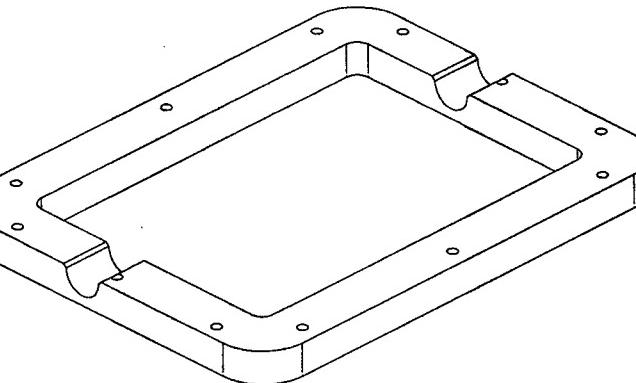
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8 7 6 5 4 3 2 1



D4173-041 POD RADALT MOUNTING PLATE ASSY

D4173-3 POD RADALT DOUBLER

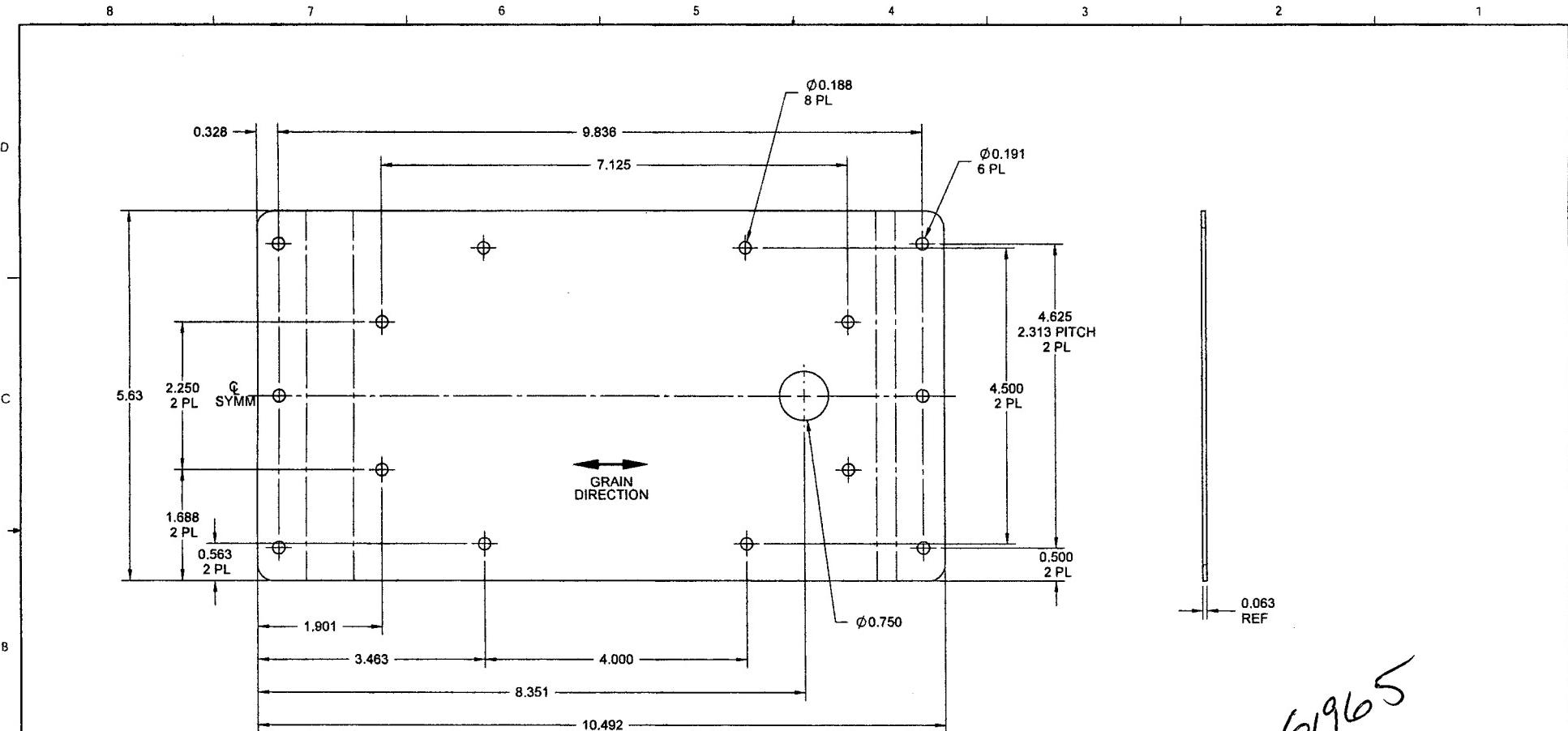


D4173-7 RADALT SCHIM

61965

PRELIMINARY ISSUE
10.09.15

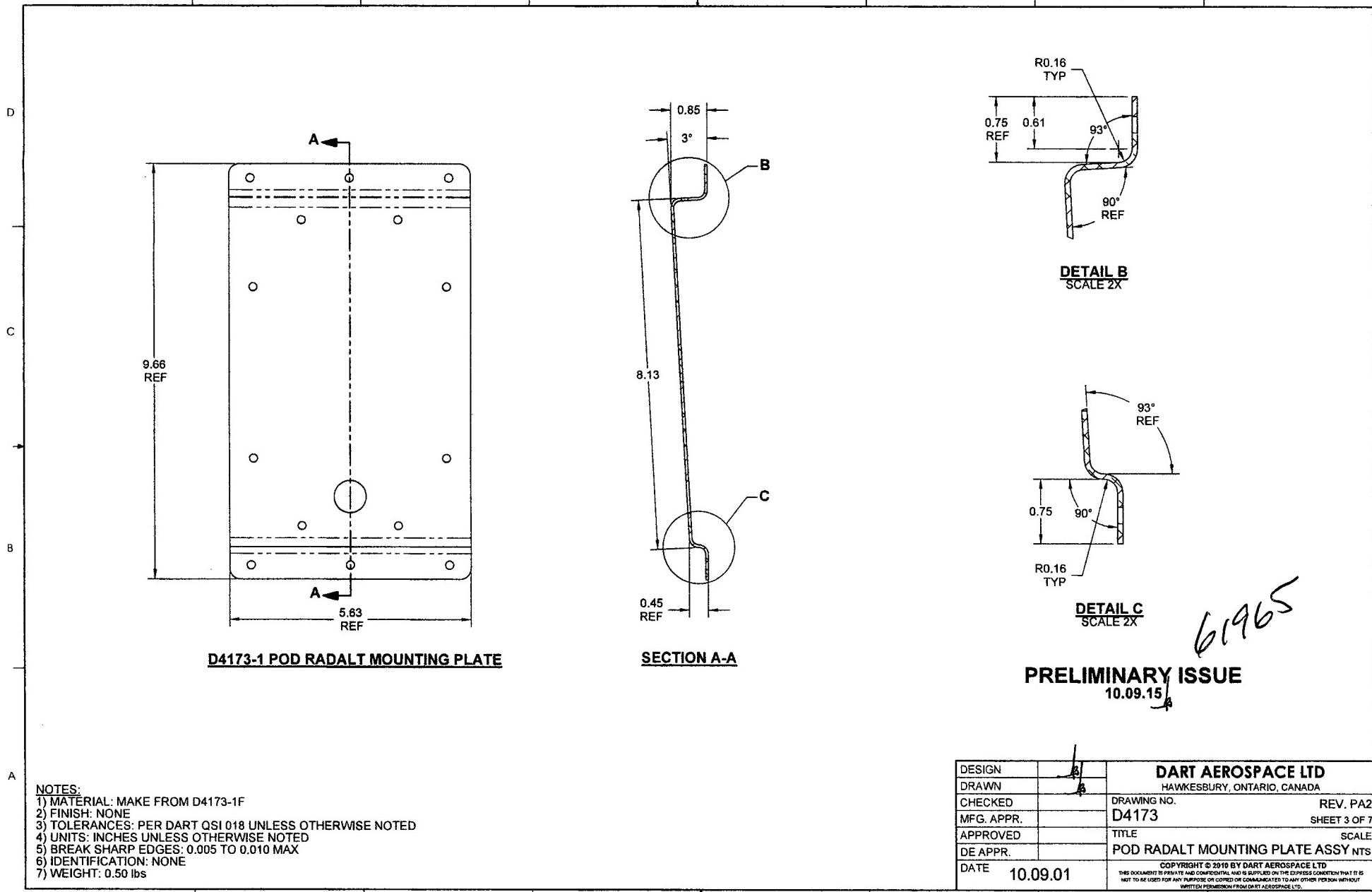
PA2	REVISED GROOVE IN D4173-7; ADDED TOL ON D4173-7 THICKNESS	MB	10.09.15
PA1	NEW ISSUE	MB	10.09.01
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA2
MFG. APPR.		D4173	SHEET 1 OF 7
APPROVED		TITLE	SCALE
DE APPR.		POD RADALT MOUNTING PLATE ASSY NTS	
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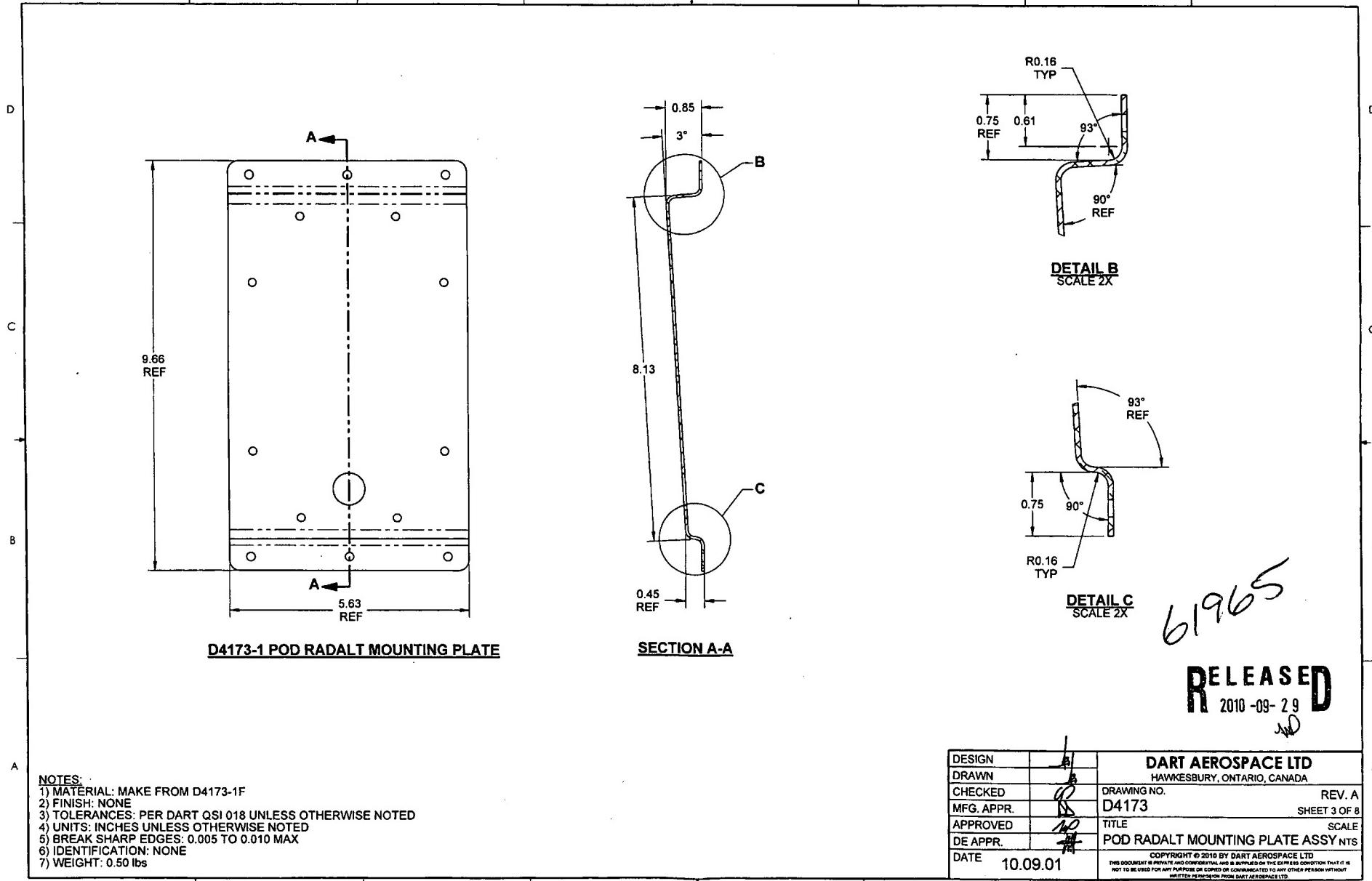
PRELIMINARY ISSUE
10.09.15

DESIGN	<i>13</i>	DART AEROSPACE LTD	
DRAWN	<i>13</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4173	
MFG. APPR.		REV. PA2	SHEET 4 OF 7
APPROVED		TITLE	SCALE
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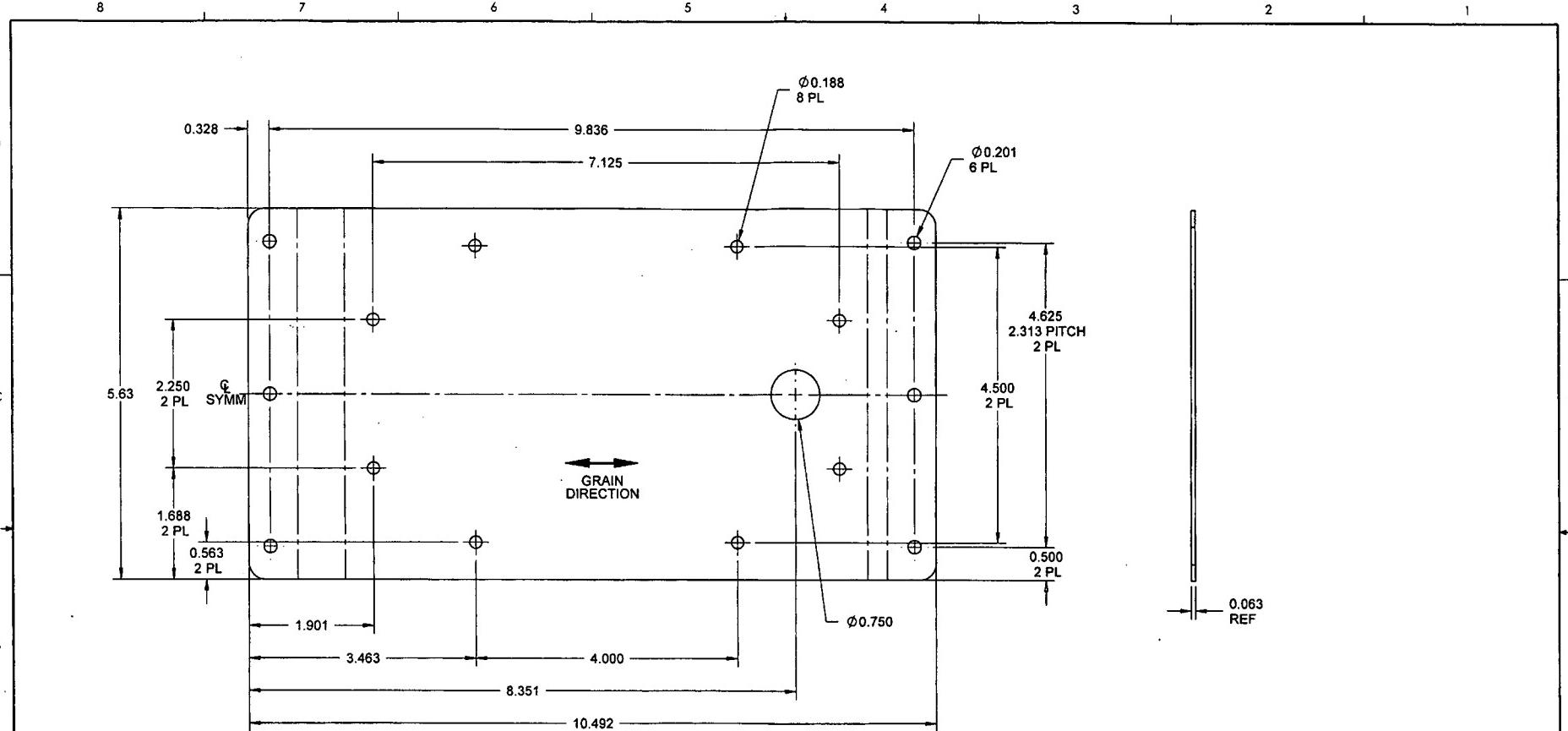
8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1



D4173-1F POD RADALT MOUNTING PLATE FLAT PATTERN

RELEASED
2010-09-29
[Handwritten signature]

A NOTES:

- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.36 lbs

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	REV. A
MFG. APPR.	<i>[Signature]</i>	D4173 SHEET 4 OF 8
APPROVED	<i>[Signature]</i>	TITLE
DE APPR.	<i>[Signature]</i>	SCALE
DATE	10.09.01	POD RADALT MOUNTING PLATE ASSY NTS

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